Dart Aerospace Ltd.

Date: Wednesday, 2/6/2008 10:24:32 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 37245		
Estimate Number	: 10493		
P.O. Number	:	Part Number	: D32043
This Issue	: 2/6/2008 S.O. No. :	Drawing Number	: D3204 REV. A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 35875	Material	:
Written By	:	Due Date	: 2/19/2008 Qty: 5 Um: Each
Checked & Approved By	: 08 02 06		
Comment	: Est:C 05.08.11 Added Step 25 KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X02000	6061-T6 Bar .50" x 2.0"

Comment: Qty.: 0.5815 f(s)/Unit Total : 2.9075 f(s)
Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8)
(M6061T6B0.500x02.000) Batch: M17037

J.L 08/02/11 (6)

2.0	BAND SAW	BAND SAW

Comment: BAND SAW
Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000)

08-02-11

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
1- Machine as per Folio FA344 and Dwg D3204
2- Deburr
Identify as D3204-3

J.L 08/02/12 (6)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/02/12 (6)

5.0	QC8	SECOND CHECK

Comment: SECOND CHECK

08-02-12 (6)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Wednesday, 2/6/2008 10:24:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** ARM

Job Number: 37245 **Part Number:** D32043

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: PAT O

8/4/12 (6)

7.0	QC21	FINAL INSPECTION/W/O RELEASE

08.02.13

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

mi 2008/2/12 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37245
Description: Arm	Part Number:	D3204-3
Inspection Dwg: D3204 **Rev:** A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.00	+/-0.030	6.00	✓			
5.25	+/-0.030	5.25	✓			
0.776	+/-0.010	.776	✓			
Ø0.760	+0.005/-0.000	.762	✓			
0.080	+/-0.010	.080	✓			
R0.50	+/-0.010	R.50	✓			
2.373	+/-0.010	2.373	✓			
0.750	+/-0.010	.750	✓			
R0.380	+/-0.010	R.380	✓			
Ø0.375	+0.001/-0.000	.3755	✓			
0.300	+/-0.010	.301	✓			

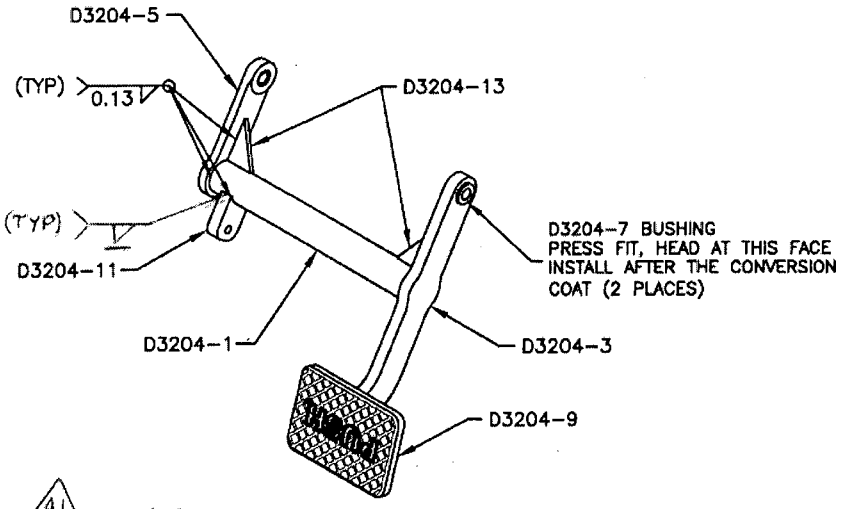
Measured by:	J.L	Audited by:		Prototype Approval:	N/A
Date:	08/02/11	Date:	08-02-12	Date:	N/A

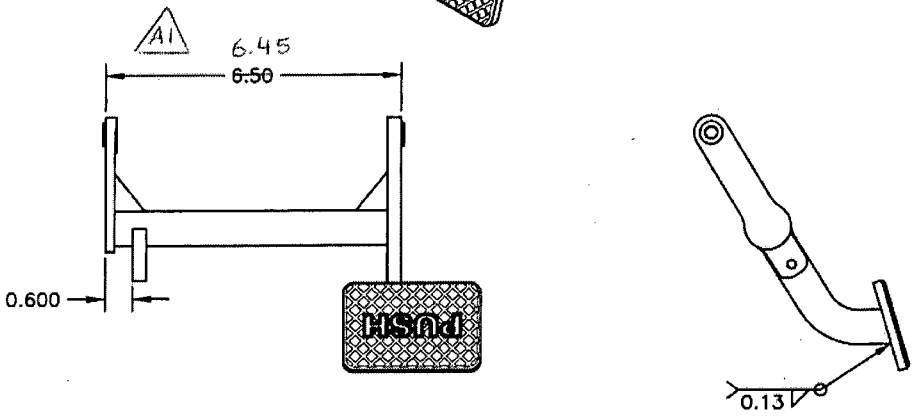
Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	06.03.21	Dwg Rev update	KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

A	04.01.27	NEW ISSUE
A1	05.07.15	6.45 WAS 6.50

RELEASED 04.04.30





D3204-041 RELEASE PEDAL ASSEMBLY

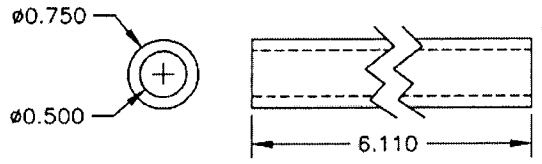
NOTES
1) BREAK ALL SHARP EDGES 0.005 TO 0.015
2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
4) MATERIAL: AISI 303 SS (M303R)
5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
   ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
7) WELD ASSEMBLY PER QSI 004
8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
11) ALL DIMENSIONS ARE INCHES

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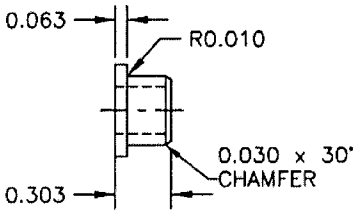
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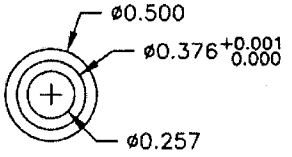
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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

RELEASED
04.04.05

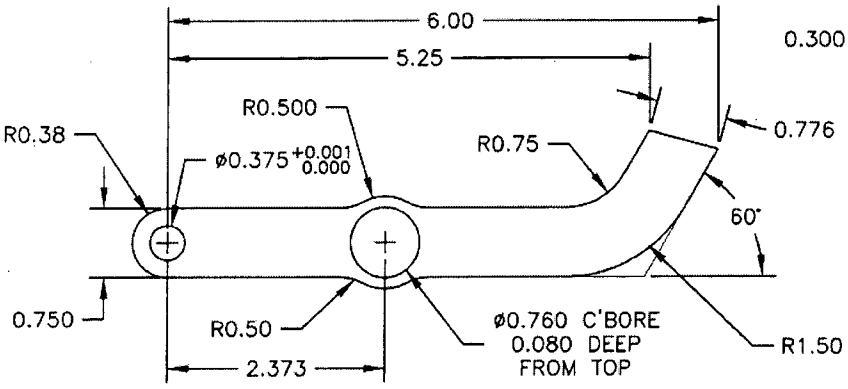


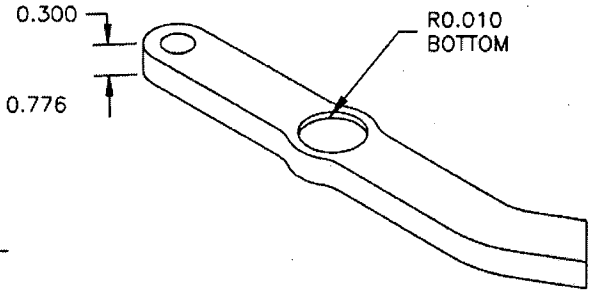
2 D3204-1 TUBE
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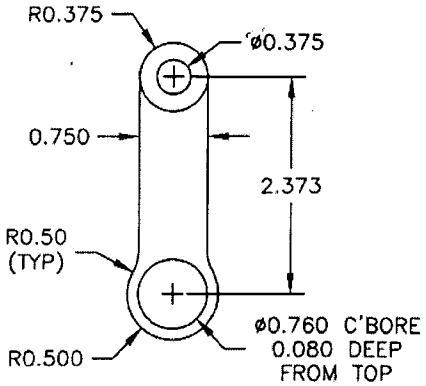


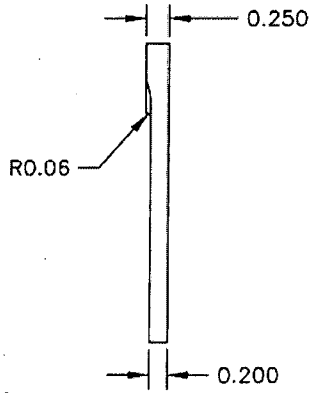
4 D3204-7 BUSHING
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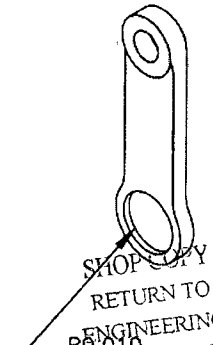


3 D3204-3 ARM
SCALE 1:2





3 D3204-5 ARM
SCALE 1:2

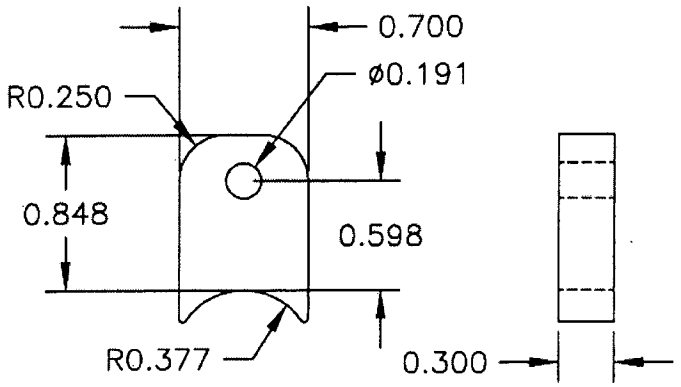


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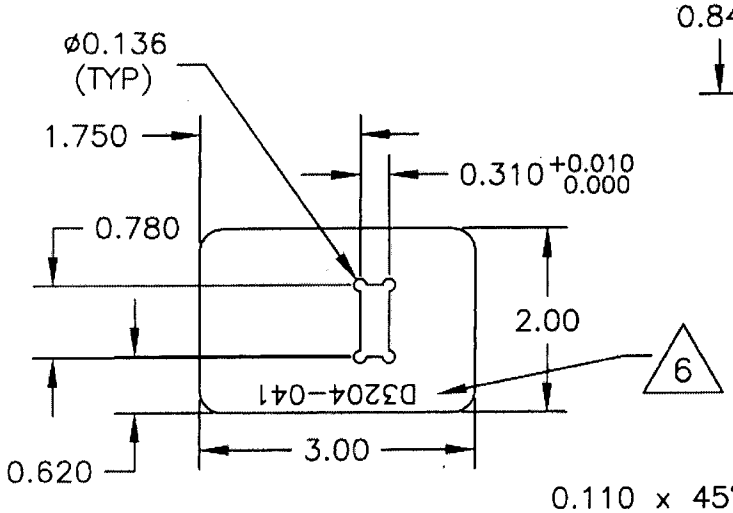
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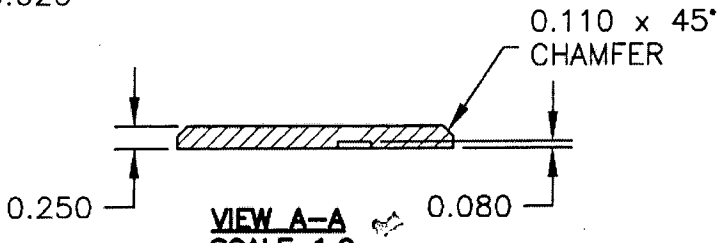
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CHECKED	APPROVED	DRAWING NO. D3204 — REV. A — SHEET 3 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY — SCALE NTS

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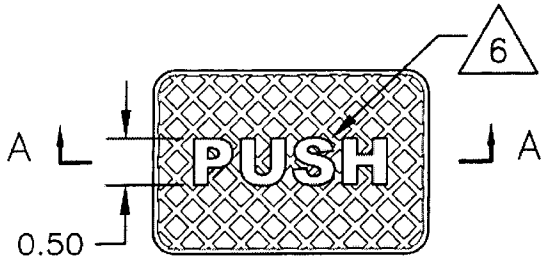


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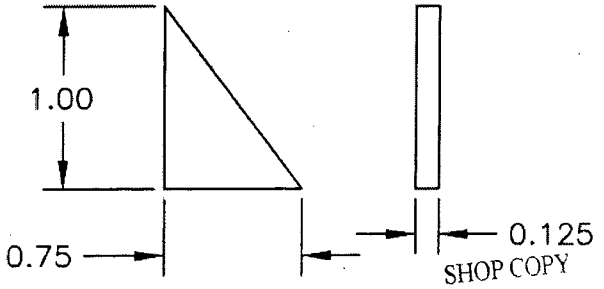




VIEW A-A
SCALE 1:2



3 D3204-9 PEDAL
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5 D3204-13 GUSSET
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